

Work Order ID 147498

Thursday, July 07, 2016 11:18:29 AM

147498

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Item ID: D3136-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Window Assembly
 Start Date: 5/31/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/15/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3136	F								
100	FLOW WATER JET	0.02							
100									
Waterjet	Memo	0.08				4			
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>F</u> Prog Rev: <u>F</u>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01				4			
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.01				(4)			
Quality Control									

PK 2016/08/08

DAS
45
9-89

PK 2016/08/08

DAS
45
9-89

DAS
16
9-89

16/02/08

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Window Assembly

Start Date: 5/31/2016 Start Qty: 4.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							DAS 07 9-89
130	THERMOFORMING MACHINE					4			16/08/15
Thermoform	Memo	0.38							
Thermoforming Machine	1-Deburr if necessary								
	2-Thermoform as per Dwg D3136 and Work Instruction WI002								
	Dwg Rev. <u>F</u>								
	WI Rev. <u>E</u>								
	3- Engrave Part # and Batch # , and affix labels (D3136-3)								
140		0.00							DAS 07 9-89
140	HAND FINISHING THERMOFORMING					4			16/08/15
Thermoform	Memo	0.33							
Thermoforming Machine	Water sand and buff to remove scratches as required								

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Start Date: 5/31/2016 Start Qty: 4.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC5- Inspect part completeness to step on W/O	0.00							
170									DAS
QC	Memo	0.01							9
Quality Control	Inspect edge and window deformation, wrap in plastic								9-89
180	Identify as per dwg & Stock Location: ST438	0.00							
180									DAS
Packaging	Memo	0.01							6
Packaging									9-89
190	QC21- Final Inspection - Work Order Release	0.00							
190									DAS
QC	Memo	0.07							21
Quality Control									9-89

4 16-05-16**4** **Ac****AUG 16 2016****DAS**
21
9-89 **AUG 17 2016****DAS**
21
9-89**AUG 17 2016**

Picklist Print

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Parent Item: D3136-043

D3136-043

Parent Item Name: Window Assembly

Start Date: 5/31/2016

Required Date: 7/15/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A04.02.04New issueKJ/DS
IPP Rev.B 07.05.29 Thermoform in-house DL
IPP rev C 07.09.28 Rev E dwg EC verified by:DD IPP Rev:D
10.06.24 added note in qc5 seq 170 DD verf:EC IPP Rev E 14/01/20
Replace "Folio" with Work Instruction DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3108-9		Manufactured	No			100	Each	181.0000	2	8			DAS 07 9-89
D3108-9									**				
Decal													

Location	Loc Qty	Loc Code
ST017	181	
138645	181	

MACRLICS.125	Purchased	No				170	sf	155.7670	3.9	15.6			
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MACRI ICS 125

1/8" Polycast II Sheet

Location	Loc Qty	Loc Code
MAT019	155.767	
m130047	15.467	
m131524	51.7	
m132799	8.7	
m133510	5.3	
m134641	64	
m135073	10.6	

17.8

16/08/19

PK 2016/08/08





